

IN THE CLAIMS:

Please cancel claims 8 and 13-24 without prejudice or disclaimer of the subject matter thereof.

The following is a complete listing of claims in this application.

1. (currently amended) Process for the manufacture of a work hardened product made of a high mechanical strength Al-Zn-Mg-Cu ~~aluminium~~ aluminum alloy comprising:

- casting an ingot made of an alloy with composition (% by weight) Zn=7.0-11.0, Mg=1.8-3.0; Cu=1.2-2.6, at least one of the elements Mn (0.05-0.4), Cr (0.05-0.3), Zr (0.05-0.20), Hf (0.05-0.5), V (0.05-0.3), Ti (0.01-0.2) and Sc (0.05-0.3), the remainder being made of ~~aluminium~~ aluminum and inevitable impurities,

- ~~possibly homogenisation of~~ optionally homogenizing said ingot,

- hot ~~transformation of~~ transforming said ingot by rolling, extrusion or forging,

- solution heat ~~treatment~~ treating said optionally homogenized ingot and quenching of the product obtained,

- ~~possibly~~ optionally controlled stretching of the quenched product with a permanent set between 1 and 5%, and

- ~~annealing of~~ artificially aging the quenched and optionally stretched the product at a temperature and with a duration equivalent to about 100-230 hours at 120°C, ~~such that the product reaches the maximum~~ sufficient to maximize compression yield strength in the L direction.

2. (currently amended) Process according to claim 1, wherein the alloy contains magnesium ~~content of the alloy is~~ between 1.8 and 2.4%.

3. (currently amended) Process according to claim 1, wherein the alloy contains copper ~~content of the alloy is~~

between 1.6 and 2.2%.

4. (currently amended) Process according to claim 1, wherein the alloy contains ~~magnesium content of the alloy is~~ between 1.8 and 2.4%, and ~~the copper content is~~ between 1.6 and 2.2%.

5. (currently amended) Process according to claim 1, wherein the alloy is a 7349 or 7449 aluminum alloy.

6. (currently amended) Process according to claim 1, wherein the alloy is a 7055 aluminum alloy.

7. (currently amended) Process for the manufacture of a work hardened product made of a high mechanical strength Al-Zn-Mg-Cu ~~aluminium~~ aluminum alloy comprising:

- casting an ingot made of an alloy with composition (% by weight) Zn=7.0-11.0, Mg=1.8-3.0, Cu=1.2-2.6, at least one of the elements Mn (0.05-0.4), Cr (0.05-0.3), Zr (0.05-0.20), Hf (0.05-0.5), V (0.05-0.3), Ti (0.01-0.2) and Sc (0.05-0.3), the remainder being made of ~~aluminium~~ aluminum and inevitable impurities,

- ~~possibly homogenisation of~~ optionally homogenizing said ingot,

- hot ~~transformation of~~ transforming said ingot by rolling, extrusion or forging,

- ~~dissolution~~ solution heat treating the transformed ingot and quenching ~~of~~ the resulting product,

- ~~possibly~~ optionally controlled stretching ~~of the~~ quenched product with a permanent set between 1 and 5%,

- single step ~~annealing~~ artificially aging the optionally stretched product at a temperature and with a duration included within ~~the a~~ a parallelogram AEFG, ~~in which the~~ having vertices ~~in the temperature-duration diagram have~~ with the following coordinates in a temperature-duration diagram:

~~A: 120°C-100 h E: 145°C-5 h F: 150°C-40 h G: 120°C-700 h~~

A: 120°C-100 h B: 145°C-9 h C: 145°C-22 h D: 120°C-230 h.

Claim 8 (canceled).

9. (currently amended) Process according to claim 1, wherein the artificial aging time equivalent ~~annealing time~~ at 120°C is between 100 and 250 h.

10. (currently amended) Process according to claim 1, wherein the artificial aging time equivalent ~~annealing time~~ at 120°C is 50 to 200 h longer than the time corresponding to temper T651.

11. (currently amended) Process according to claim 1, wherein said ~~annealing~~ artificial aging is a two-step ~~annealing~~ aging comprising a first step at a temperature between 80°C and 120°C, and a second step at a temperature between 120°C and 160°C, and wherein ~~said the~~ the artificial aging time equivalent ~~annealing time~~ at 120°C is between 100 and 250 h.

12. (currently amended) Process according to claim 1, wherein said ~~annealing~~ artificial aging is a three-step ~~annealing~~ aging comprising a first step at a temperature between 80°C and 120°C, a second step at a temperature between 120°C and 160°C, and a third step at a lower temperature than the second step and between 100°C and 140°C, and wherein the artificial aging time equivalent ~~annealing time~~ at 120°C is between 100 and 250 h.

Claims 13-24 (canceled).